



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

0006497

646.4003
Job Sheet 186235



Part No: 646.4003

Job Qty: 1 ea

Part Name: AS350 Cable Cutter System Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/11/18	12/11/18	0.00	0.00	Start Up Stores/Pkg-1		NOV 16 2018
110	Packaging	1 pcs	12/11/18	12/11/18	0.00	0.00	Packaging1-1		NOV 16 2018
120	QC	1 pcs	12/11/18	12/11/18	0.00	0.00	QC4		NOV 19 2018
130	Packaging	1 pcs	12/11/18	12/11/18	0.00	0.00	Packaging3-1		NOV 19 2018
135	DC	1 pcs	12/11/18	12/11/18	0.00	0.00	DC		NOV 19 2018
140	QC21-FG	1 Ea	12/11/18	12/11/18	0.00	0.00	QC21		NOV 19 2018

Part Op 130 - Identify and pack for shipping as per PPP 646.4003 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4003

DAS
21
9-89

NOV 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	90-Start up Operation	5031229
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5121187
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	90-Start up Operation	5121188
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5119525
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	90-Start up Operation	5119441
646.2910	Deflector	1 Ea (1 ea)	90-Start up Operation	5079498
646.3001	Lower Cable Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5125414
646.3110	Channel	1 Ea (1 ea)	90-Start up Operation	547183
646.3301	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	5104489
646.3510	Strut	1 Ea (1 ea)	90-Start up Operation	5050453
646.3511	Strut	1 Ea (1 ea)	90-Start up Operation	5081639
646.3610	Filler	1 Ea (1 ea)	90-Start up Operation	5092525
646.3711	Clip	1 Ea (1 ea)	90-Start up Operation	5038779
646.3712	Clip	1 Ea (1 ea)	90-Start up Operation	5026726
646.3716	Gauge Bracket	1 Ea (1 ea)	90-Start up Operation	5039275
646.3718	Custom Washer	2 Ea (2 ea)	90-Start up Operation	5038803
646.3811	Radius Block	1 Ea (1 ea)	90-Start up Operation	5070843
646.3910	Shim	4 Ea (4 ea)	90-Start up Operation	5083586
646.3911	Shim	1 Ea (1 ea)	90-Start up Operation	5041250
646.3912	Shim	4 Ea (4 ea)	90-Start up Operation	5076145
646.3913	Shim	1 Ea (1 ea)	90-Start up Operation	5126060
646.9410	Shim	1 Ea (1 ea)	90-Start up Operation	5056448

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS be ☐ b ☐ g ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐
		MRB (QSI042) Approval
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

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 Newmarket, ON A6A 1K7
 CANADA
 TEL: 1 613 502-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S128635
 Part: 646-4003
 Job No: 186235
 Serial No/Batch: S128635
 Revision: C1
 Inspector:
 Exp Date:
 Instructions: FAA STC SR02180LA 08/12/16, T6aSTC SH09-10 Issue 1, BRAZIL

Root Cause	CURE	CATEGORY
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No I ☐ Oper ☐ Offset ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : ☐	Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐

#3 JOB 180235

006497

647.0112	Strut Bracket	2 Ea (2 ea)	90-Start up Operation	5097197
647.7703	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	5118480
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	90-Start up Operation	5092170
AN3-11A	Bolt	10 Ea (10 ea)	90-Start up Operation	5098034
AN3-12A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095479
AN3-13A	Bolt	1 Ea (1 ea)	90-Start up Operation	5099032
AN3-4A	Bolt	6 Ea (6 ea)	90-Start up Operation	5060063
AN3-5A	Bolt	2 Ea (2 ea)	90-Start up Operation	5119258
AN3-6A	Bolt	2 Ea (2 ea)	90-Start up Operation	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	90-Start up Operation	5080637
AN44-5A	Eyebolt	2 Ea (2 ea)	90-Start up Operation	5104032
AN4C7A	Bolt	2 Ea (2 ea)	90-Start up Operation	5095478
AN665-34R	Clevis	2 Ea (2 ea)	90-Start up Operation	5065264 5127749
MS20426AD5-7	Rivet	2 Ea (2 ea)	90-Start up Operation	7153848
MS21042-08	Use Ms21042L08	2 Ea (2 ea)	90-Start up Operation	5100409
MS21042-3	Nut	2 Ea (2 ea)	90-Start up Operation	5108577
MS21042L3	Nut	53 Ea (53 ea)	90-Start up Operation	5094592
MS21042L4	Nut	2 Ea (2 ea)	90-Start up Operation	5109736
MS24693-C278	Screw	5 Ea (5 ea)	90-Start up Operation	5065341
MS24694-S51	Screw	5 Ea (5 ea)	90-Start up Operation	5004859
MS24694-S54	Screw	2 Ea (2 ea)	90-Start up Operation	5118346
MS24694-S55	Screw	3 Ea (3 ea)	90-Start up Operation	5099526
MS27039-08-13	Screw	2 Ea (2 ea)	90-Start up Operation	5016508
MS27039-1-12	Screw	6 Ea (6 ea)	90-Start up Operation	5000971
MS27039-1-16	Screw	24 Ea (24 ea)	90-Start up Operation	5104364
MS27039-1-19	Screw	22 Ea (22 ea)	90-Start up Operation	5071413
MS27039-1-20	Screw	2 Ea (2 ea)	90-Start up Operation	5094554
MS27039-1-21	Screw	4 Ea (4 ea)	90-Start up Operation	5104011
NAS1149F0332P	Washer	120 Ea (120 ea)	90-Start up Operation	5109991
NAS1149F0432P	Washer	4 Ea (4 ea)	90-Start up Operation	5123456
NAS1149FN832P	Washer	4 Ea (4 ea)	90-Start up Operation	50107796

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.0129	8	216	0
	600.0990	1	10	0
	600.0991	1	10	0
	600.1012	1	23	0
	600.1013	5	62	0
	646.2910	1	23	0
	646.3001	1	12	0
	646.3110	1	10	0
	646.3301	1	10	0
	646.3510	1	15	0
	646.3511	1	20	0
	646.3610	1	20	0
	646.3711	1	30	0
	646.3712	1	18	0
	646.3716	1	36	0
	646.3718	2	36	0
	646.3811	1	27	0
	646.3910	4	63	0
	646.3911	1	19	0
	646.3912	4	61	0
	646.3913	1	35	0
	646.9410	1	97	0
	647.0112	2	80	0
	647.7703	2	8	0
	650.9201	2	29	0
	AN3-11A	10	135	0
	AN3-12A	2	88	0
	AN3-13A	1	95	0
	AN3-4A	6	334	0
	AN3-5A	2	312	0
	AN3-6A	2	176	0
	AN316C4R	2	31	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

AN44-5A	2	25	0
AN4C7A	2	137	0
AN665-34R	2	23	0
MS20426AD5-7	2	986	0
MS21042-08	2	1	0
MS21042-3 <i>h3</i>	2	214	0
MS21042L3	<i>55</i> 53	1,944	0
MS21042L4	2	2,022	0
MS24693-C278	5	134	0
MS24694-S51	5	290	0
MS24694-S54	2	404	0
MS24694-S55	3	95	0
MS27039-08-13	2	576	0
MS27039-1-12	6	240	0
MS27039-1-16	24	549	0
MS27039-1-19	22	307	0
MS27039-1-20	2	97	0
MS27039-1-21	4	106	0
NAS1149F0332P	120	1,657	0
NAS1149F0432P	4	702	0
NAS1149FN832P	4	2,415	0

Part Specifications

Specifications could not be found.

Plex 11/13/18 10:29 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

REFERENCE ONLY

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

REFERENCE ONLY

5	5	5	78	601.3875	SCREW	MS24694554				
1	1	1	77	646.9410	SHIM	MS24694554				
	4	4	76	601.2764	WASHER	MS24694554				
	2	2	75	601.2973	LOCKNUT	MS21042-08				
	2	2	74	601.2988	SCREW	MS27039-0813				
	2	2	73	601.2943	LOCKNUT	MS21042-05				
	2	2	72	601.3128	NUT	AN316G4R				
	2	2	71	601.3209	LOCKNUT	MS21042L4				
	4	4	70	601.2638	WASHER	MS2149H0432P				
	2	2	69	601.2669	BOLT	AN4C7A				
	2	2	68	601.3119	CLEVIS	AN665-34R				
2	2	67	601.3121	EYE BOLT	AN44-5A					
		2	66	650.9201	EYE BRACKET ASSY					
	REF	REF	65	647.5701	GPS MOUNT KIT	MS24694553				
		2	64	601.3151	WASHER	MS2149F03M3P				
		2	63	601.2911	SCREW	MS24694553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT	PR-1420 CLASS B				
	1	1	53	600.0991	MAGNOBOND 6396 PART B					
	1	1	52	600.0990	MAGNOBOND 6396 PART A					
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-1R				
	2	2	48	601.1365	SCREW	MS27039-1-10				
2		2	47	646.3719	DOUBLER					
	2	2	46	646.3718	CUSTOM WASHER					
1		1	45	646.3717	DOUBLER					
	22	2	44	601.1948	SCREW	MS27039-1-19				
	2	2	43	601.1952	SCREW	MS27039-1-20				
	4	4	42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 02119 & 02745	03/08/2010	P. BRAVO
B	INCORPORATED ECN 02048, 02079 & 04731	11/04/2014	P. BRAVO
C	INCORPORATED ECN 02058	07/09/2015	P. BRAVO

		2	2	41	601.2829	SCREW	MS24694554			
		2	2	40	601.2831	RIVET	MS20470ADS-7			
		1	1	39	646.3716	GAUGE BRACKET				
		6	6	38	601.1953	SCREW	MS27039-1-12			
	2	2	2	37	646.3715	STRUT DOUBLER				
		2	2	36	601.2824	BOLT	AN3-5A			
12	36		36	35	601.2277	RIVET	CCR2445-3-00			
6	18		18	34	600.0795	NUTPLATE	MS21047-3			
3	3		3	33	601.2565	RIVET	MS20470ADS-7			
1	1		1	32	646.3813	STRUT BRACKET				
4	4		4	31	601.2822	BOLT	AN3-3A			
2	2		2	30	646.3812	GUSSET BRACKET				
8	8		8	29	601.2564	RIVET	MS20470ADS-6			
1	1		1	28	646.3714	GUSSET				
	1		1	27	646.3610	FILLER				
	3		3	26	601.2830	SCREW	MS24694553			
	2		2	25	601.2825	BOLT	AN3-5A			
	1		1	24	646.3811	RADIUS BLOCK				
	1		1	23	646.3712	CLIP				
	1		1	22	646.3711	CLIP				
8	8		8	21	601.2832	RIVET	MS20470ADS-5			
14	14		14	20	601.2020	RIVET	CP3213-5-3			
4	6	4	6	10	19	601.2823	BOLT	AN3-4A		
	1		1	18	601.2827	BOLT	AN3-13A			
	5		5	17	601.2912	SCREW	MS24694551			
1	1		1	16	646.3713	GUSSET				
1			1	15	646.3210	SUPPORT				
		1		14	646.3710	DOUBLER				
		1		13	646.3110	CHANNEL				
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042L3	
16	32	18	120	16	144	11	601.1607	WASHER	NAS1149F0322P	
				10	646.3410	LH WIPER DEFLECTOR				
				9	646.3411	RH WIPER DEFLECTOR				
		2		2	8	647.7703	STRUT ASSY			
		2		2	7	647.0112	STRUT BRACKET			
	1		1	1	6	646.3511	STRUT			
	1		1	1	5	646.3510	STRUT			
2		2		2	4	646.3810	BRACKET			
			1	1	3	646.2910	DEFLECTOR			
			1	1	2	646.3001	LOWER CUTTER ASSY			
			1	1	1	646.3301	UPPER CUTTER ASSY			
X						646.4006	LOWER CUTTER TIED PROVISIONS			
	X					646.4005	LOWER CUTTER REMOVABLE PROVISIONS			
		X				646.4004	FIXED PROVISIONS KIT			
			X			646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS			
				X		646.4002	ASS350 WIPER DEFLECTOR KIT			
					X	646.4001	ASS350 CABLE CUTTERS KIT			
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		NEXT ASSY (S)		ORIGINAL DATE IMO DA: 19-08-2008 DRAWN BY: J. BRAVO S. HUBB DRAWING APPROVAL P. BRAVO 08/20/08 CONTRACT NO.		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300 APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DIMENSIONS SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.005 3 PLACE DECIMALS ±.000 ANGLES ±.5°		SIZE B		SET / GAGE CODE B 07M26		ENG. NO. 646.4000	
SCALE		NONE		SHEET		1 OF 5	

RECEIVED ONLY

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